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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D135-751-011
Job Sheet 183648



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 10/26/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:



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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S118894



Part: D135-751-011

Job No: 183648

Serial No/Batch: S118894

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01709SE 15/11/28, TC LoA RDIMS-9661680-v1 14/0

need box + labels

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Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/26/18	0.00	0.00	Start Up Skidtubes-1		
120	Skidtubes	1 pcs		10/26/18	0.00	0.80	Skidtubes-1		DAS 38
140	QC	1 pcs		10/26/18	0.00	0.00	QC5		D.R. 18/11/12
150	HandFinish	1 pcs		10/26/18	0.00	0.33	HandFinish1		MLAG
160	QC	1 pcs		10/26/18	0.00	0.00	QC7-1		DD, BE DAS 38
170	Skidtubes	1 pcs		10/26/18	0.00	1.00	Skidtubes-1		D.R. 18/11/12
180	QC	1 pcs		10/26/18	0.00	0.00	QC10		BE
185	HandFinish	1 pcs		10/26/18	0.00	0.10	HandFinish6		DAS 38
187	QC	1 pcs		10/26/18	0.00	0.00	QC7-1		BE
190	Skidtubes	1 pcs		10/26/18	0.00	0.77	Skidtubes-1		DAS 38
200	QC	1 pcs		10/26/18	0.00	0.00	QC5		D.R. 18/11/15
210	HandFinish	1 pcs		10/26/18	0.00	0.08	HandFinish2		N/R
215	Outsource	1 pcs		10/26/18			ATE003-VC	5	18-12-2
220	SprayPaint	1 pcs		10/26/18	0.00	0.25	Spray Paint		AL 18-12-2
230	QC	1 pcs		10/26/18	0.00	0.00	QC14		AL 18-12-03
260	HandFinish	1 pcs		10/26/18	0.00	0.74	HandFinish4		AL 18-12-03
270	QC	1 pcs		10/26/18	0.00	0.00	QC5		DEC 04 2018
280	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging1-1		DEC 05 2018
290	QC	1 pcs		10/26/18	0.00	0.00	QC4		DEC 07 2018
300	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging3-1		DEC 07 2018
305	DC	1 pcs		10/26/18	0.00	0.00	DC		DEC 11
310	QC21-FG	1 Ea		10/26/18	0.00	0.00	QC21		DEC 11

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.*****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375"(1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2- Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: 138876 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: 138978

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 14138943

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

DAS
33
00-0

DAS
15
0-88

DAS
68

0-88

DEC 03 1988
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DEC 03 1988
DEC 03 1988

Job BOM					6076814
Part / Item	Component Name	Quantity	Operation	Container	
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5117522	
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077412	
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	B 105604	
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5092232	
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5089938	
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	5091974	
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	5083326	
MS20601-AD4W3	Rivet	12 Ea (12 ea) +3	190-Skidtubes +	5066193-1	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5058139	
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5112899	
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5095223	
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5095214	
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	50716643	
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482	
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F 126369	
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5127306	
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5091840	
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110	
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5096801	
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5098130	
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5116343	
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5120745	
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5089465	
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697	
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5106747	
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5057609	
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5090636	
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5113705	
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5104354	

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Start up Operation	D3507-1-BENT	1	2	0	
170-Skidtubes	D3504-1	2	12	0	
	D3504-3	1	18	0	
	D3504-5	2	38	0	
	D3505-1	1	6	0	
190-Skidtubes	D3506-1	4	48	0	
	D3506-3	2	28	0	
	MS20601-AD4W3	12	889	0	
260-HandFinish	ALS4-1032-225	1	1,947	0	
	ALS7-1032-130	38	1,267	0	
	AN3C4A	31	2,249	0	
	AN3C5A	2	1,934	0	
	AN526C1032R10	2	110	0	
	D2965	1	50	0	
	D2965-3	1	10	0	
	D3492-1	4	108	0	
	D3492-3	4	153	0	
	D3492-7	2	19	0	
	D4918-047	1	7	0	
	D4918-1	1	9	0	
	D4918-3	1	8	0	
	D4918-5	1	3	0	
	NAS1149C0332R	33	5,199	0	
	NAS1611-007	2	270	0	
	NAS1611-010	4	433	0	
	NAS1611-013	4	290	0	
280-Packaging	AN3C4A	8	2,249	0	
	D3512-041	2	5	0	
	NAS1149C0332R	8	5,199	0	

Part Specifications

Specifications could not be found.

Plex 9/21/18 4:00 PM dart.white.jesse

PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER.

32.9 PARTS LIST (ICA-D135-751)**5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>OP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		REVISED WEARPLATE KIT	NTS
DATE	13.08.21	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: C

Date: 07.09.20

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Change Record

PAGE 1 OF 1

Part Number: D135-751-011

Description: SKIDTUBE

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